



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3121-041
Job Sheet 198432



Part No: D3121-041

Job Qty: 6 pcs

Part Name: Bracket Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/29/19

Job Tracking No:

Due Date: 9/2/19

Created By: Jennifer Renwick

Type: SOLD

Description: Order 13294

Note: DWG REV E IPP Rev:Pick:A 04.02.18 New issue KJ/DS IPP Rev:B ECN 1060 07-11-12 DD verified by: EC
IPP Rev:C New Dimensions for Blank Size 08-07-23 JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	6 pcs	9/2/19		0.00	0.08	Bandsaw - 1		SBL / 19/08/19
110	HAAS 4 Axis - B4B	6 pcs	9/2/19		1.00	12.02	HAAS - 1 - B4B		
							HAAS - 2 - B4B		SBL / 19/09/19
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	6 pcs	9/2/19		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		SBL 19/09/19
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		



Container No: S206756



Part: D3121 - 041
Job No: 198432
Serial No/Batch: S206756
Revision:
Inspector:
Exp Date:
Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Newbury, ON K84 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/19/19



Container No: S206756



Part: D3121-041

Job No: 198432

Serial No/Batch: S206756

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 08/19/19

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Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
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130 QC 8	6 pcs	9/2/19	0.00	0.00	QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 8 - 12	
					QC 8 - 14	ml 19/08/22
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
140 Small Fab - 2 - B4B	6 pcs	9/2/19	0.00	0.20	QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
150 QC 5	6 pcs	9/2/19	0.00	0.00	QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					Small Fab - 1 - B4B	SMB
					Small Fab - 2 - B4B	19/8/26
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
160 Packaging 3-1 - Stock - B4B	6 pcs	9/2/19	0.00	0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
160 Packaging 3-2 - B4B	6 pcs	9/2/19	0.00	0.00	QC 5 - 9	OAS
					QC 5 - 50	81
					QC 5 - 30	9-89
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
					Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	

AUG 26 2019

					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	

MD

170 QC 21 - SA	6 pcs	9/2/19	0.00	0.00	QC 21 - SA - 21	DAS	
					QC 21 - SA - 70	70	AUG 26 2019
					QC 21 - SA - 53	9-89	

STO18

Part Op 100 - Bandsaw - Cut blanks: (1.000" x 2.000") 3.250" long
Descriptions: 110 - HAAS CNC Vertical Machine - 1-Machine D3121-11 as per Folio FA331 and Dwg D3121 Identify as D3121-11 2-
Deburr 3-Scribe batch number
120 - QC2- Inspect parts off machine FAI/FAIB
130 - QC8- Inspect parts - second check
140 - Small Fab - Assemble D3121-141 as per Dwg D3121.
150 - QC5- Inspect part completeness to step on W/O
160 - Identify as per dwg & Stock Location: - Location: CA2
170 - QC21- Final Inspection - Work Order Release

Job BOM

Job BOM records could not be found.

M17-4-B 1.000x2.000	0.271 (each)	OP. 100	DAS
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Job Allocations

D3121-21 STO18	1 (each)	OP. 140	35
D3121-241 STO19	1 (each)	OP. 140	519829R

Job Allocations could not be found.

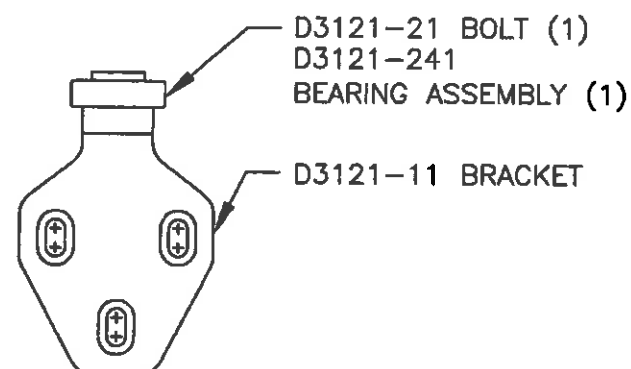
Part Specifications

Specifications could not be found.



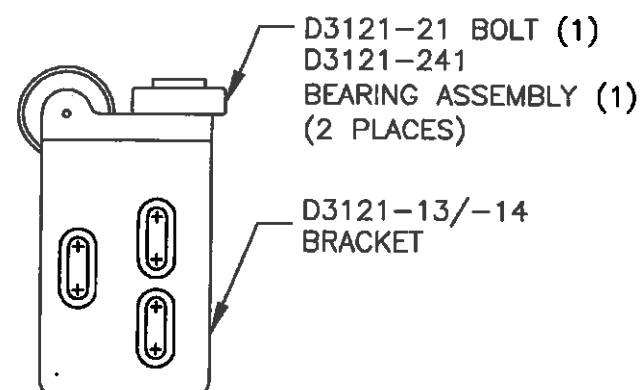
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CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 1 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2
A	02.04.15	NEW ISSUE	
B	03.01.16	ADD RIDGES; ADD MAT'L PROP; FIX P/N ADD -141/-143/-144/-145/-146	
C	04.02.17	ADD CLEARANCE; USE -241 BEARING	
D	06.05.17	D3121-25 CAP WAS 1.024, NOW 1.000	
E	07.11.07	ADD TOLERANCE TO 0.032 (DETAIL B)	

RELEASED
07.11.07

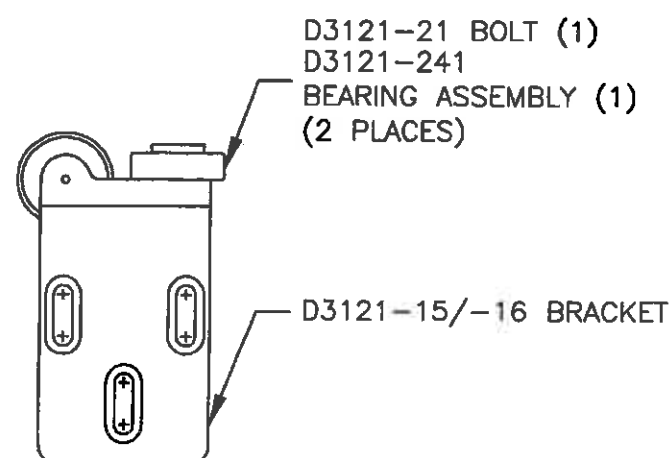


D3121-041 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-33)

SHUT COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 198432



D3121-043 (SHOWN) / D3121-044 (OPPOSITE) BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-37/-38)



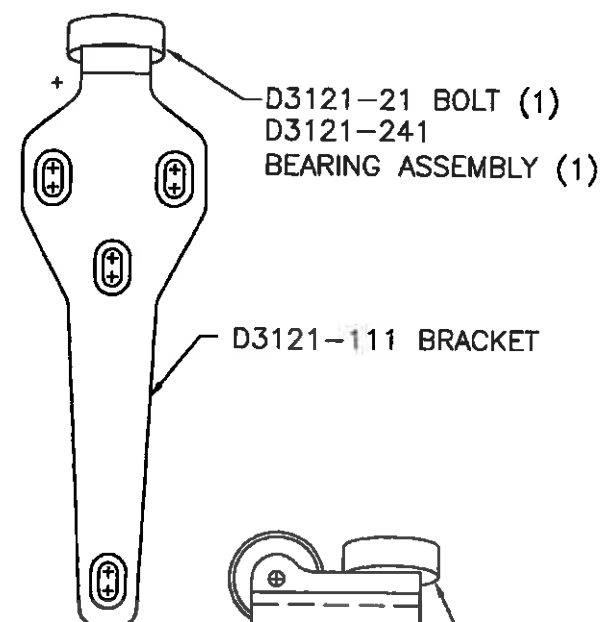
D3121-045 (SHOWN) / D3121-046 (OPPOSITE) BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-35/-36)

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DATE 07.11.07	TITLE BRACKET ASSEMBLY		SCALE 1:2

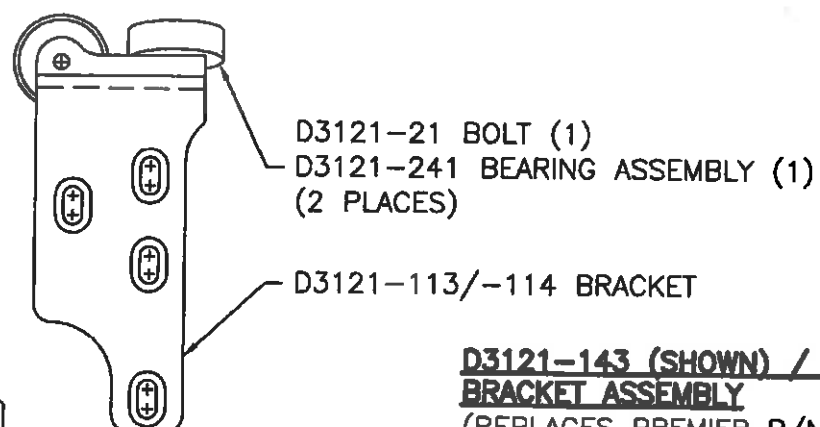


D3121-21 BOLT (1)
D3121-241
BEARING ASSEMBLY (1)

D3121-111 BRACKET

D3121-141 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23001-01)

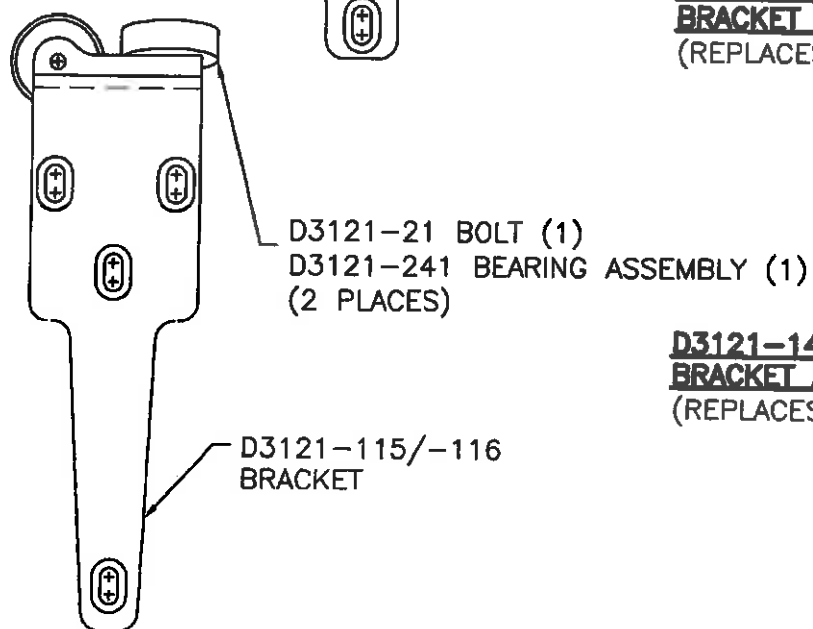
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07.11.07



D3121-21 BOLT (1)
D3121-241 BEARING ASSEMBLY (1)
(2 PLACES)

D3121-113/-114 BRACKET

**D3121-143 (SHOWN) / D3121-144 (OPPOSITE)
BRACKET ASSEMBLY**
(REPLACES PREMIER P/N B30-23000-03/-04)



D3121-21 BOLT (1)
D3121-241 BEARING ASSEMBLY (1)
(2 PLACES)

D3121-115/-116
BRACKET

**D3121-145 (SHOWN) / D3121-146 (OPPOSITE)
BRACKET ASSEMBLY**
(REPLACES PREMIER P/N B30-23000-05/-06)

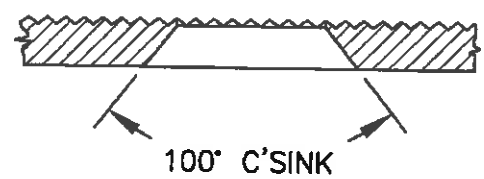
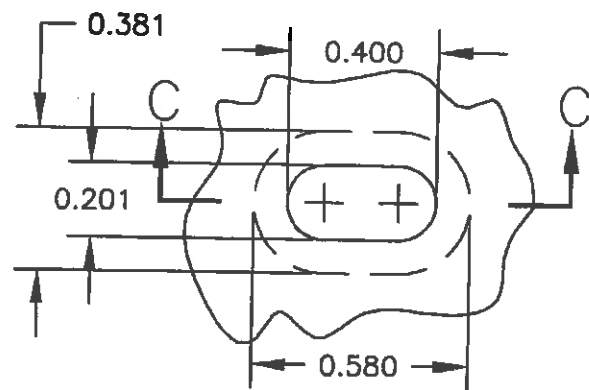
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DATE 07.11.07	TITLE BRACKET ASSEMBLY		SCALE 1:1

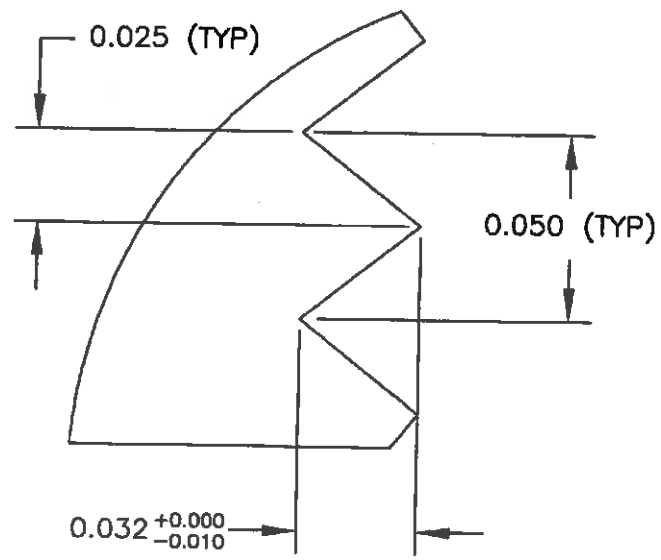
DETAIL A:
SLOT DETAIL
SCALE 2:1
VIEW ROTATED



SECTION
C-C

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07.11.07

DETAIL B:
RIDGE DETAIL
PARTIAL SECTION
SCALE 1:20

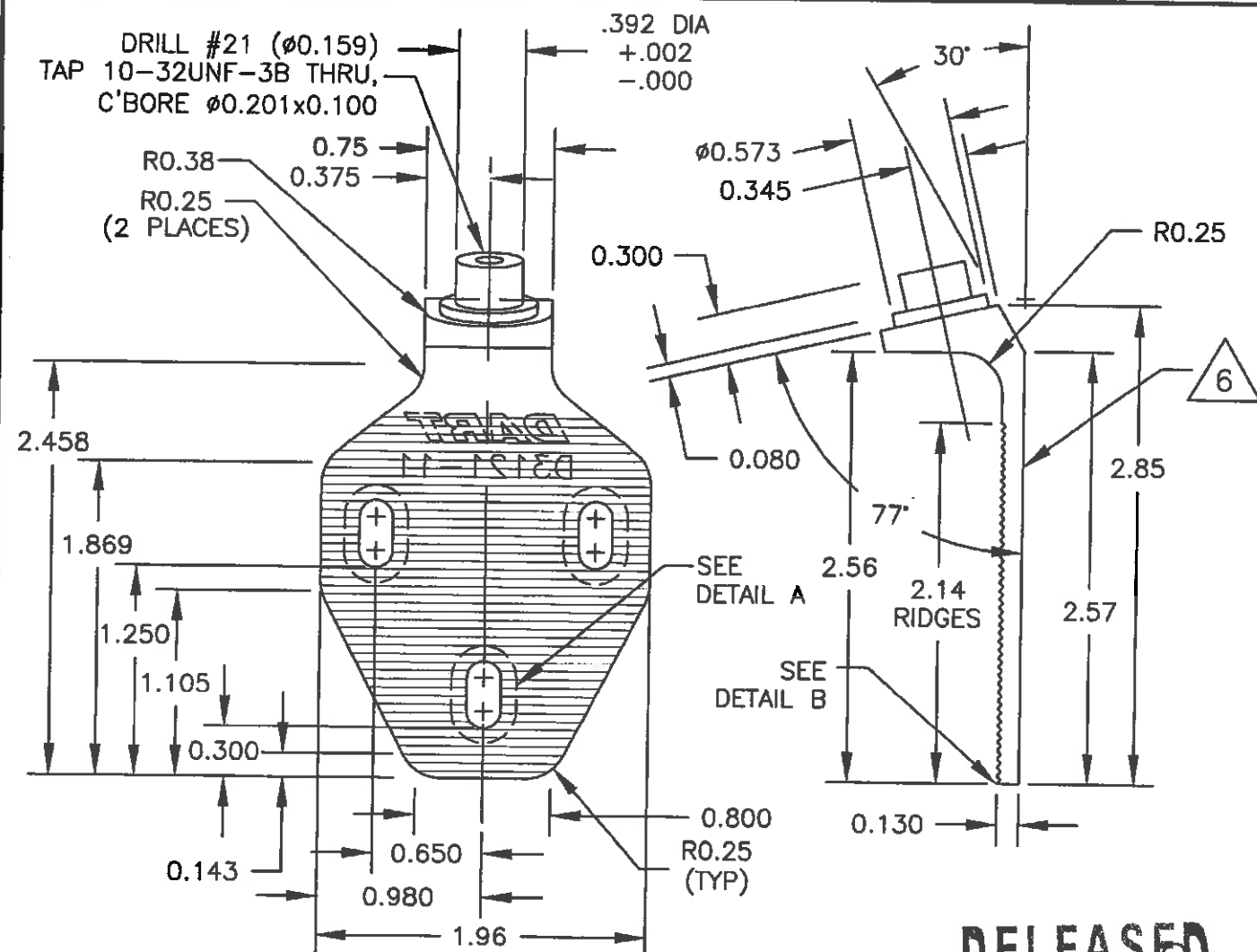


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DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1

**RELEASED**
07.11.07**D3121-11 BRACKET**

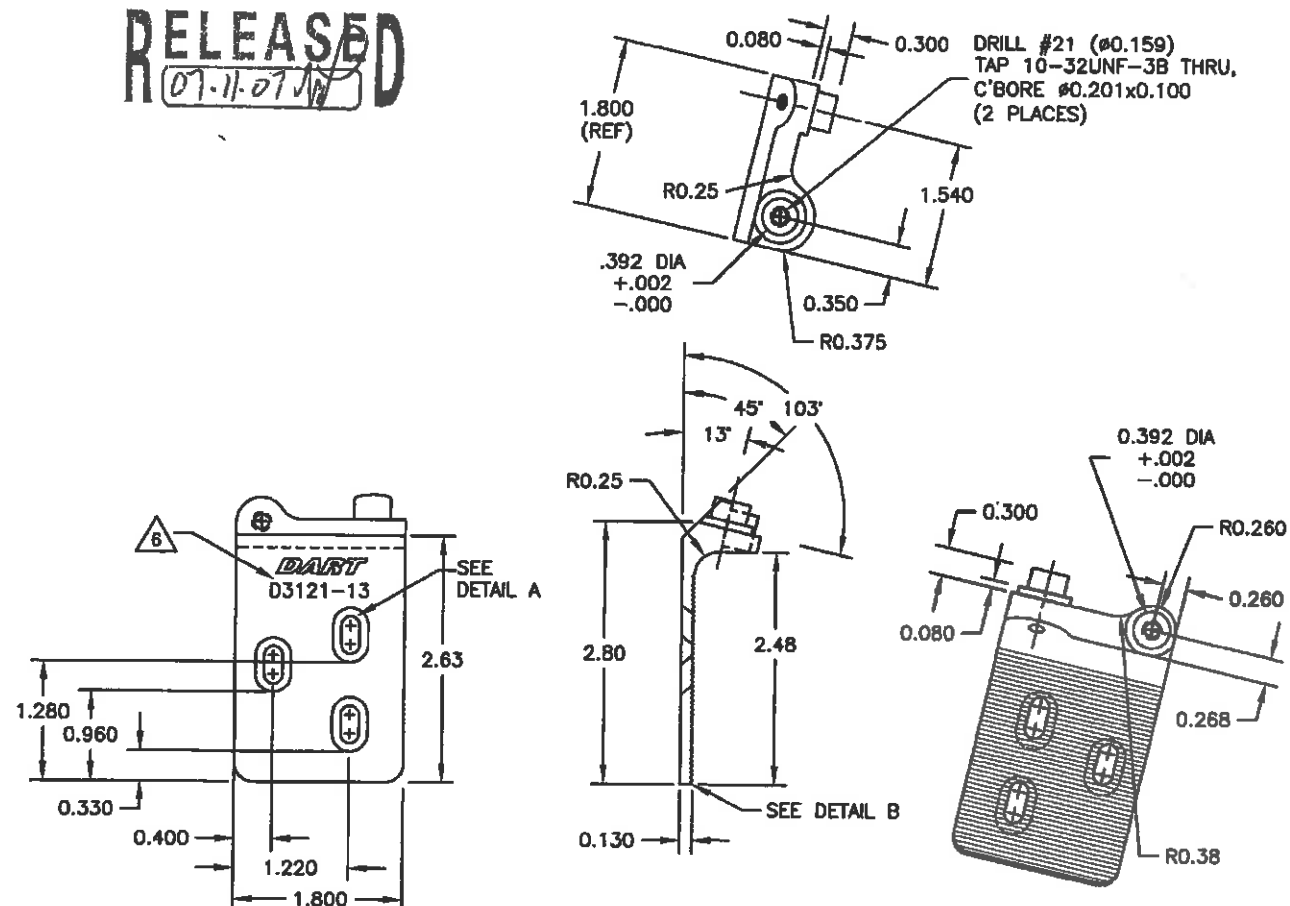
- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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DATE 07.11.07	TITLE BRACKET ASSEMBLY		SCALE 1:2

RELEASED
07-11-07**D3121-13 BRACKET (SHOWN)****D3121-14 BRACKET (OPPOSITE)**

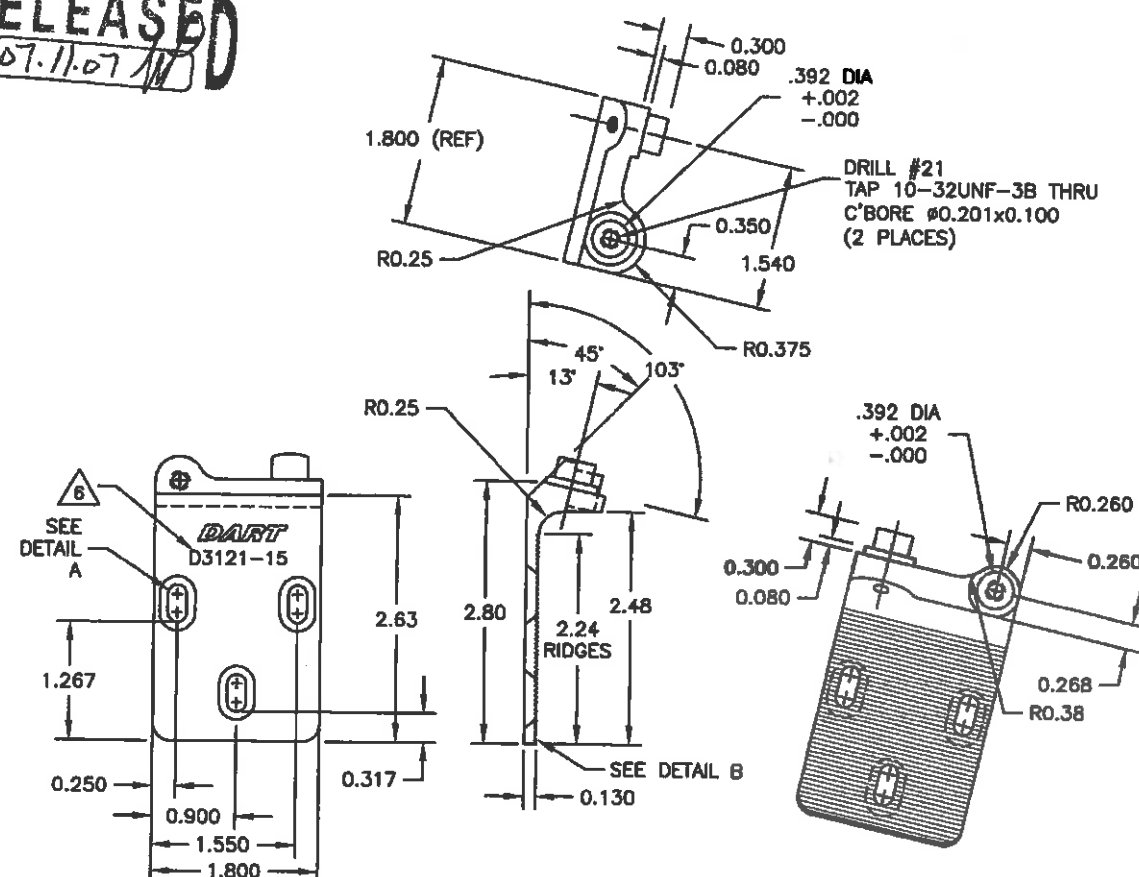
- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
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DATE 07.11.07	TITLE BRACKET ASSEMBLY		SCALE 1:2

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07.11.07

D3121-15 BRACKET (SHOWN)
D3121-16 BRACKET (OPPOSITE)

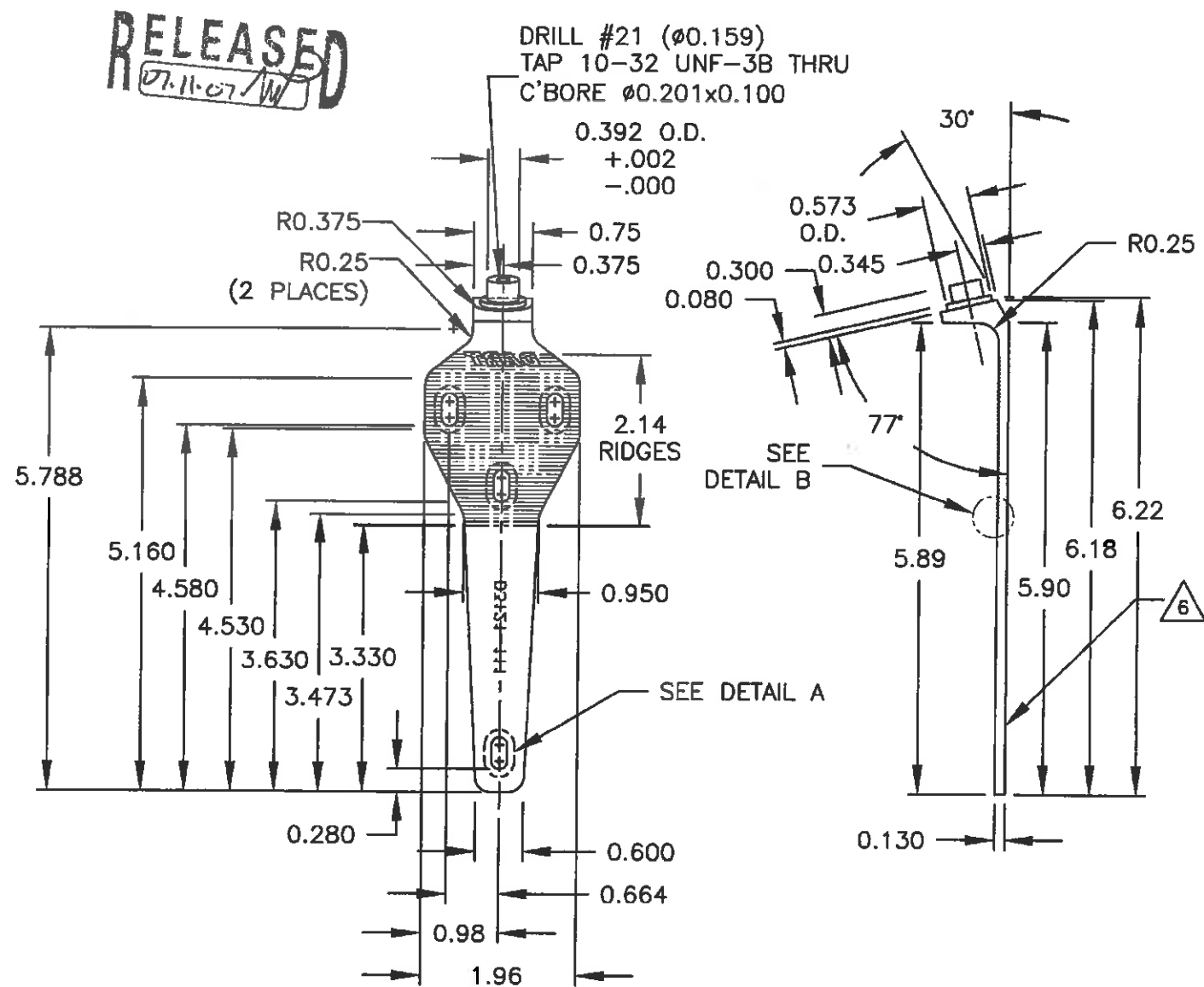
- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N AND LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

**D3121-111 BRACKET**

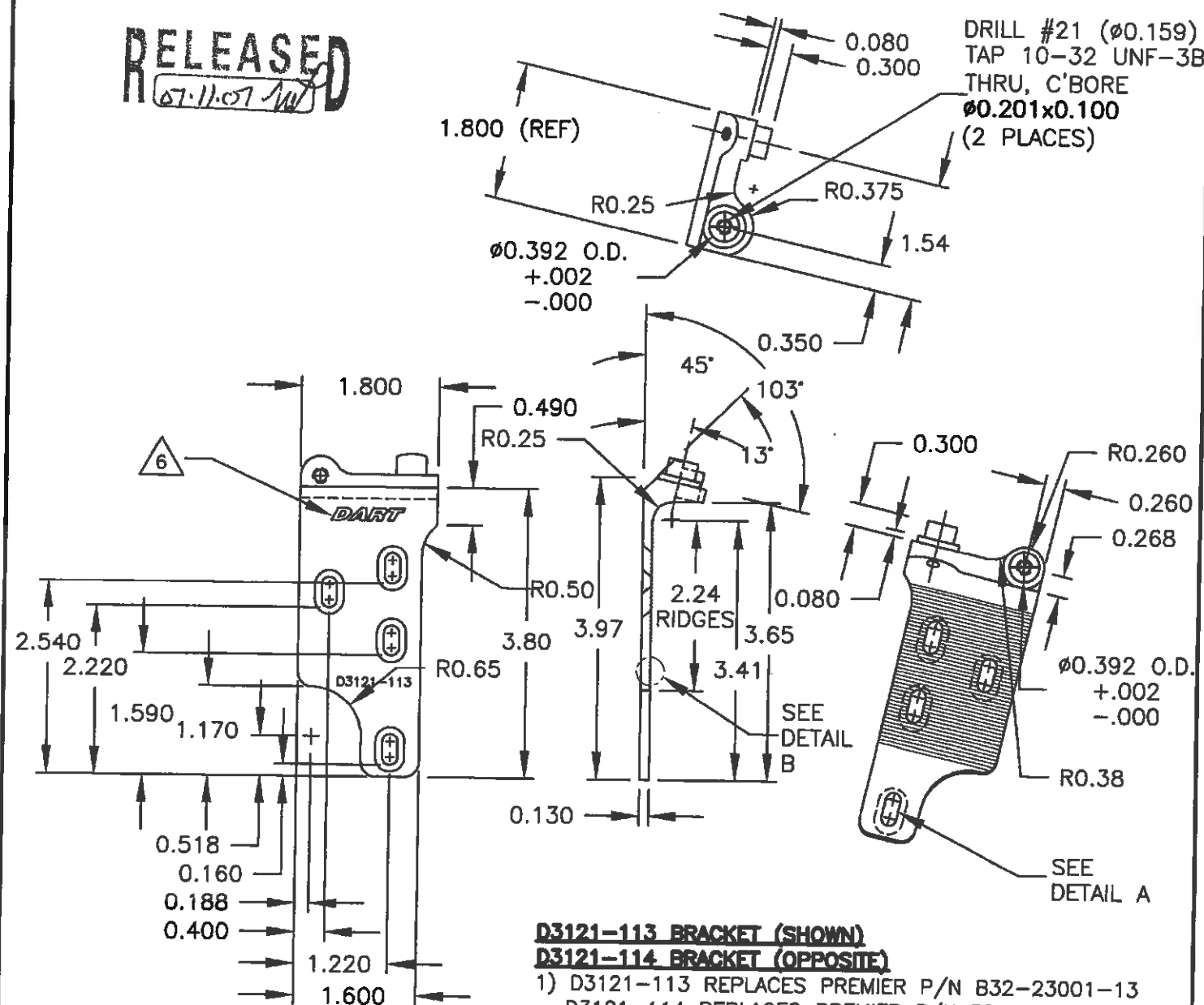
- 1) REPLACES PREMIER P/N B32-23001-11
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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DATE 07.11.07	TITLE BRACKET ASSEMBLY		SCALE 1:2

RELEASED
07.11.07**D3121-113 BRACKET (SHOWN)****D3121-114 BRACKET (OPPOSITE)**

- 1) D3121-113 REPLACES PREMIER P/N B32-23001-13
D3121-114 REPLACES PREMIER P/N B32-23001-14
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES

5) BREAK ALL SHARP EDGES 0.005 TO 0.015

6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN

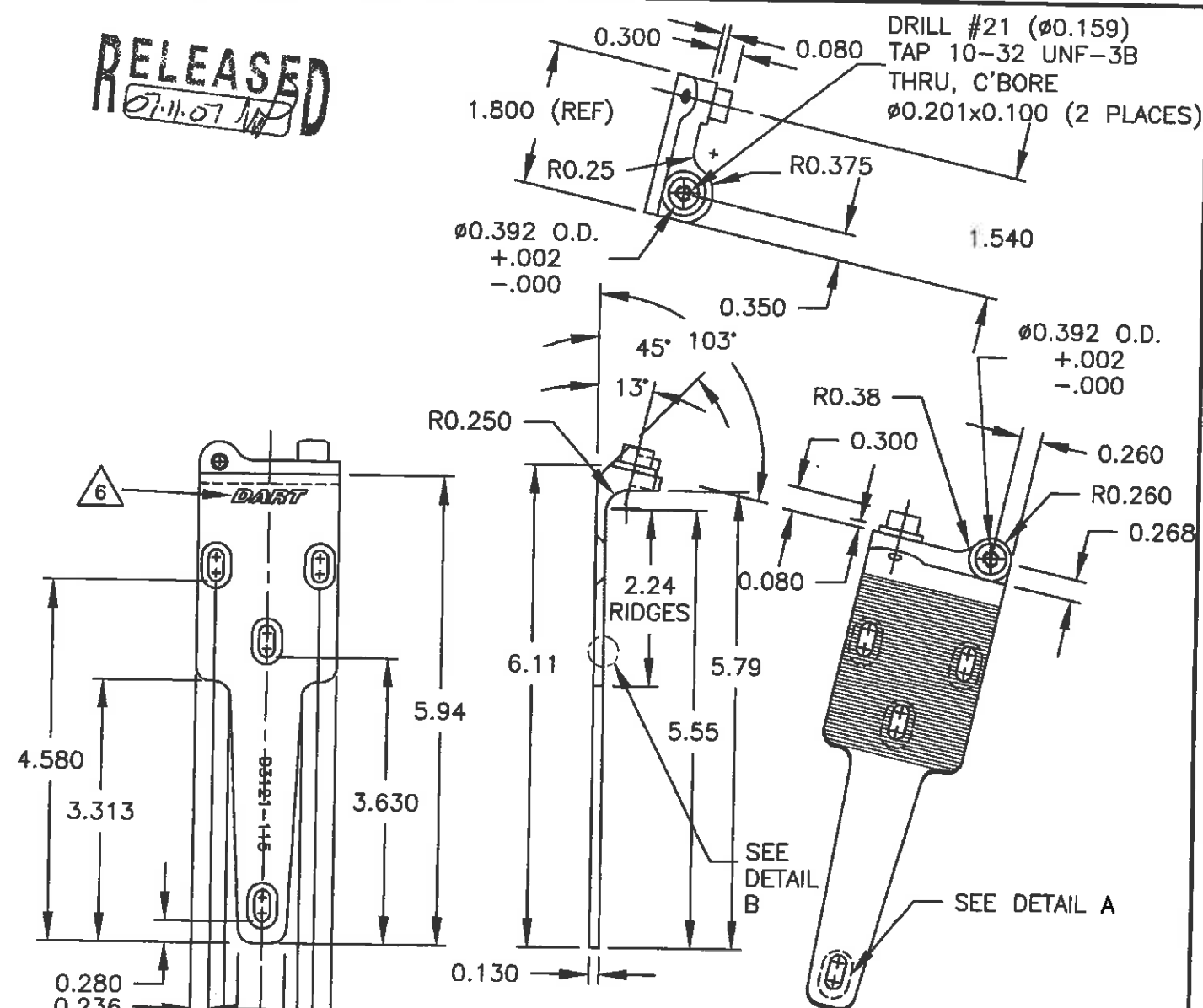
7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 9 OF 10
DATE 07.11.07	TITLE BRACKET ASSEMBLY		SCALE 1:2

RELEASED
07.11.07**D3121-115 BRACKET (SHOWN)****D3121-116 BRACKET (OPPOSITE)**

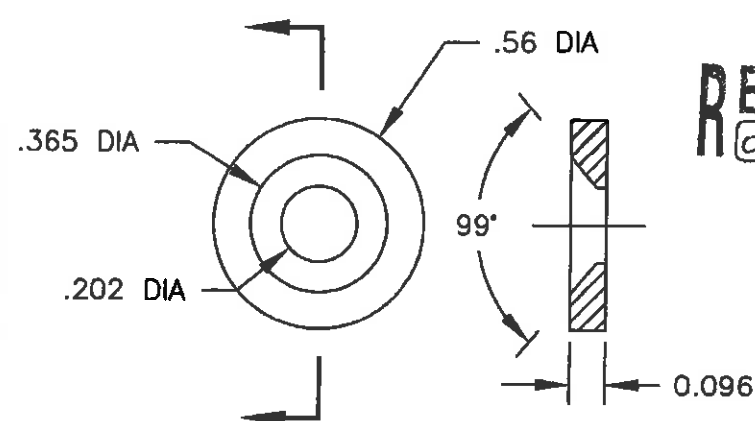
- 1) D3121-115 REPLACES PREMIER P/N B32-23001-15
D3121-116 REPLACES PREMIER P/N B32-23001-16
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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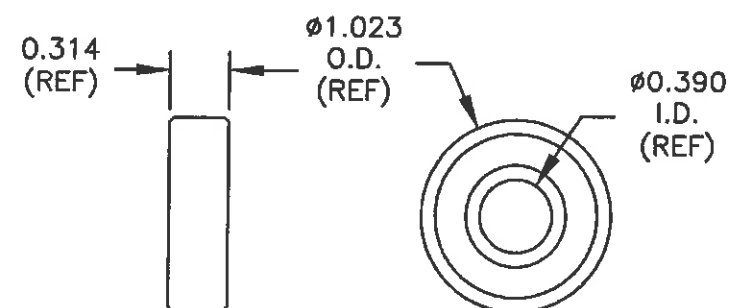
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DESIGN #	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 10 OF 10
DATE 07.11.07	TITLE BRACKET ASSEMBLY		SCALE 1:1



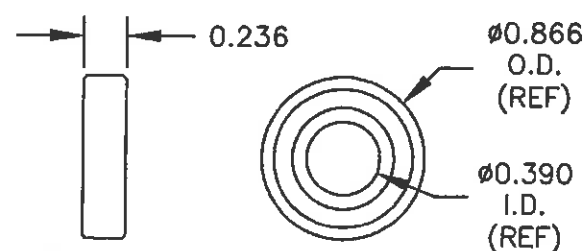
D3121-17 WASHER (SCALE 2:1)

- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



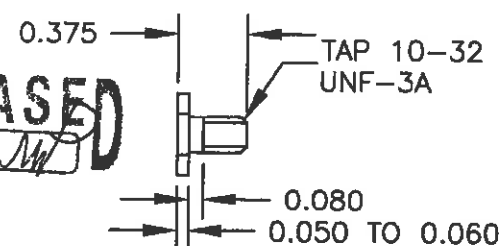
D3121-19 BEARING (SCALE 1:1)

- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES



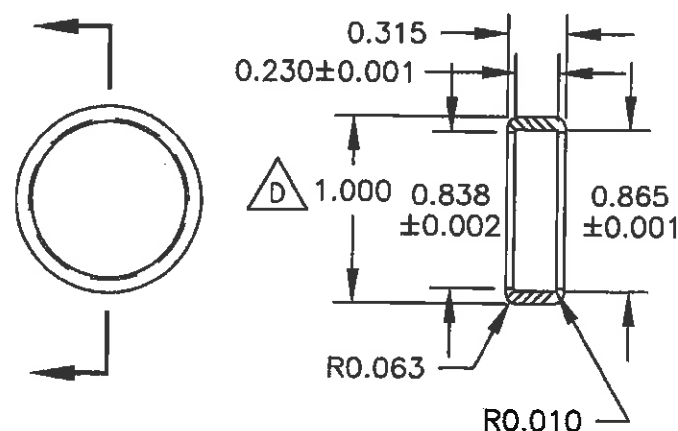
D3121-23 BEARING (SCALE 1:1)

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES



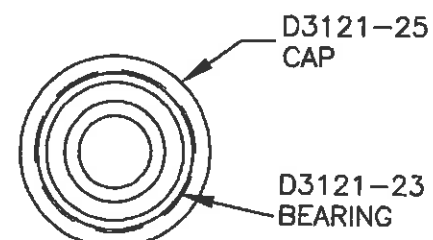
D3121-21 BOLT (SCALE 1:1)

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



D3121-25 CAP (SCALE 1:1)

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES



D3121-241 BEARING ASSEMBLY (SCALE 1:1)

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DART AEROSPACE LTD		Work Order:	198 432
Description: Bracket		Part Number:	D3121-11
Inspection Dwg: D3121	Rev: E	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.392	+0.002/-0.000	1938	✓		mic.	Seb-201
Ø0.201 x 0.100	+/-0.010	201 x .094	✓		P.G + Vern	
0.75	+/-0.030	751	✓		Vern	
0.375	+/-0.010	375	✓			
1.250	+/-0.010	1240	✓			
0.300	+/-0.010	290	✓			
1.96	+/-0.030	1961	✓			
Ø0.573	+/-0.010	573	✓		PG	
0.345	+/-0.010	345	✓			
0.300	+/-0.010	300	✓			
0.080	+/-0.010	080	✓			
2.56	+/-0.030	2558	✓			
2.14	+/-0.030	2120	✓			
0.130	+/-0.010	131	✓			
2.57	+/-0.030	2570	✓			
2.85	+/-0.030	2852	✓			
0.381	+/-0.010	382	✓			
0.400	+/-0.010	399	✓			
0.201	+/-0.010	202	✓			
0.580	+/-0.010	578	✓			
0.032	+0.000/-0.010	030	✓		PG	

Measured by: DAS 57	Audited by: [Signature]	Prototype Approval:	N/A
Date: 9-89 19/08/14	Date: 19/08/22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.01	New Issue P/O D3121-041	KJ/EC/DD	
B	08.06.02	Tolerance revised for Ø0.573	KJ/DD [Signature]	[Signature]

Entered: _____ Date: 19/08/19

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐



Job: <u>198 438</u>		DISPOSITION		DEPARTMENT/PROCESS				MRE (QS1042)			
Part No. <u>D3121-11</u>		Rework ☐ Scrap ☒ Use-as-is ☐		Skid-tube ☐ Machining ☒ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date: <u>19/08/14</u>	Sequence #: <u>110</u>	QTY Affected: <u>2</u>		Disposition		Completed By <u>DAS 57</u> <u>19/08/14</u> Lead hand / Supervisor <u>9-89</u> <u>19-08-14</u>					
Description Work Order Deviation								QC / QA Coordinator <u>DAS 68</u> <u>AUG 14 2019</u>			
<i>Pieces have more in them and</i> <i>-tap 10-32 38 broke into spigot hole while completing the thread. by hand.</i>				<i>scrap and replace</i> <i>and</i> <i>scrap and replace</i>							
Root Cause				FAULT CATEGORY							
Operator ☒ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☒ Incomplete/Unclear Instructions ☐ Drill Holes ☒ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐							
<i>See serial 103 of part</i>											

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☒ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date: 19/6/22	Sequence #: _____	QTY Affected: _____		MRB (OS1042) 1WSF 9/19/22 RZ 9/19/22	
Description Work Order Deviation		Disposition		Completed By 9/19/22 Lead hand / Supervisor 9/19/22 QC / QA Coordinator	
Slots are 0.350 wide (dwg = 0.381)		Acceptable. Screw head is flush & sufficient engagement with 80-605-Z-8 insert.			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____		☐ Contamination Misaligned/off center BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐	